Date:

Friday, 19/12/2008 8:15:01 AM

User: Melanie Fauteux

Process Sheet

Customer

: CC-DAR01 Dart Aerospace Ltd.

S.O. No. :

Job Number **Estimate Number** : 44191

First Issue

Written By

Previous Run

P.O. Number

This Issue : 19/12/2008 Prsht Rev.

: NC

: //

: 10804

: 43382

Type : MACHINED PARTS

18-12-19

Part Number

Drawing Name

: D26511 - D2651-1

: BLUE

Drawing Number Project Number

Drawing Revision Material

Due Date : 26/12/2008 Qty:

200 Um:

Each

Checked & Approved By

Comment

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M6061T6R0500

6061-T6 Round Bar .500"

Comment: Qty.:

0.0421 f(s)/Unit Total: 8.4210 f(s)

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia

(M6061T6R0500)

Batch: <u>H109396</u>

2.0



Comment: HAAS CNC VERTICAL MACHINING #1

1- Turn as per Folio FA219 and Dwg D2651

2- Deburr



3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SMALL FAB 1

SMALL & MEDIUM FAR RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651

08/12/20



Dart Aerospace

W/O:		WORK ORDER CHANGES	Ş					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			<u> </u>					
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			<u>. </u>		<u>.</u>			

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	_
Resolution	n:	Disposition:	QA: N/C Closed	d:	Date:	

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	Section A Init	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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NOTE: Date & initial all entries

Date: Friday, 19/12/2008 8:15:01 AM User: Melanie Fauteux **Process Sheet** Customer: CC-DAR01 Dart Aerospace Ltd. **Drawing Name: BLUE** Job Number: 44191 Part Number: D26511 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 SPRAY PAINTING SPRAY PAINTING Comment: -PRIME B_1/O 199 -PAINT DELFLEET BLUE B 110077 -CLEAR DELFLEET B 110169 21 08-12-22 only large section necessary 8.0 QC14 INSPECT SPRAY PAINT Comment: INSPECT spray painting 08 12 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1

Identify and Stock

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Location:

QC21

Job Completion

10.0



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			!					

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed	l:	Date:

NCR: WORK ORDER NON-CONFORMAL								
	T.	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
								
								•

NOTE: Date & initial all entries

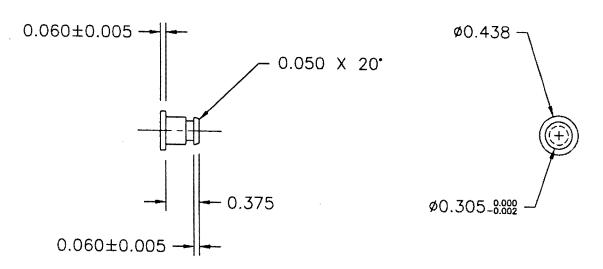




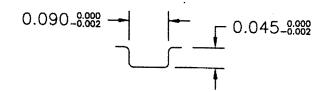
	DESIGN	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	•
	CHECK	#	APPROVED	D2651	V. B OF 1
	DATE				CALE
_	03.1	12.19		PLUG	1:1
	A		97.03.25	NEW ISSUE	
	В		03.12.19	ADD POWDER COAT, MS28775-008	***************************************



D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1) RENCE ONLY



* 44191

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER 3/16 ID, 5/16 OD, 1/16 WIDTH (PARKER 2-008, MS28775-008 OR EQUIVALENT)

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	WORK ORDER CH	WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		}						
	• ••							
		; ; ;					·	
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

		WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
	Description of NC		Corrective Action Section B		Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
1.			;				*
							•
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Vernication Section C	STEP Description of NC Section A Description

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 449

Description: Plug

Part Number: D2651-1

Inspection Dwg: D2651 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST										
X First Article Prototype										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments			
0.060	+/-0.005	.059								
0.375	+/-0.010	.375								
0.050 x 20°	+/-0.010	058×20°								
Ø0.305	+0.000/-0.002	0.304	/							
Ø0.438	+/-0.005	436								
0.060	+/-0.005	, 540								
0.090	+0.000/-0.002	010	/							
0.045	+0.000/-0.002	.044								
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·										
·										
			7/							
Measured by:		Audited by:			Prototype Approval:		N/A			
Date:	e: 68/12/20 Date: 68.12.22 Date:									

	Rev	Date	Change	Revised by	Approved
L	Α	03.12.22	New Issue	KJ/RF	
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